

Work Order ID 147168

June 06, 2016 10:11:46 AM

U/R

147168

For bell

Page 1

Item ID: D412-775-013

Revision ID: URF 16-532

Item Name: Step Protective Trim

Start Date: 6/6/2016 Start Qty: 1.00

Required Date: 6/7/2016 Req'd Qty: 1.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals:

Process Plan: SHADate: 6/6/16

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

DSI 9503

A

IIN D412-775

Rev A U/R

OK 4/16/6/7

JUN 07 2016

DAS

6

9-89

MC 16-06-08

100

Document Control

0.00

100

DC

DOCUMENT CONTROL

Memo

0.00

Doc.Control -USB or Paperwork

Photocopy bluefile & type labels per PPP D412-775-013 CHG003

105

Pick Kit

0.00

105

Packaging

Memo

0.00

Packaging

DAS

28

9-89

JUN 07 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>747768</u> Part No. <u>3</u> NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date : _____		Step #: _____		QTY Effective : _____		MRB (QS1042) Approval 	
Description Work Order Deviation				Disposition			
				Completed By _____			
				Lead hand / Supervisor Approval Verification _____			
				QC / QA Coordinator Approval _____			
Root Cause		FAULT CATEGORY					
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due ☐	Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐	Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐	Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐		
OTHER : _____							

Work Order ID 147168

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147168

Page 2

Item ID: D412-775-013 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: URF 16-532 Stop ***NS2***
 Item Name: Step Protective Trim
 Start Date: 6/6/2016 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 6/7/2016 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
110 *110* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.01	DAS 28 9-89	27 9-89		Sole			
120 *120* Packaging Packaging	Packaging Memo Identify and pack for shipping as per PPP D412-775-013 Location: FG028	0.00 0.00				DAS 28 9-89	DAS 27 9-89	JUN 21 2016	
130 *130* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.02						JUN 20 2016	

JUN 20 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date : _____	Step #: _____	QTY Effective : _____		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐ Design ☐ Doc/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐	☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ Manufacturing Process ☐ Past Due	☐ Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter	☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes	☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Mislabeled ☐ Fit/Function ☐ Misaligned/off center	☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence
OTHER : _____					

Picklist Print

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Page 1

Work Order ID: 147168

147168

Parent Item: D412-775-013

D412-775-013

Parent Item Name: Step Protective Trim

Start Date: 6/6/2016

Required Date: 6/7/2016

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:A 08-12-10 new issue DD verified by:ec IPP Rev:B add pick
kit DD 10.02.18 Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

D3608-1		Manufactured	No			110	Each	14.0000	1	1			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3608-1

Lower Doubler

DAS
27
9-89

Do Not Pull from Stock
Use Batch 147167
from Pet Duels office
Location 147167

**

147167

DAS
28
9-89

JUN 15 2016

D3608-3		Manufactured	No			110	Each	15.0000	1	1			
---------	--	--------------	----	--	--	-----	------	---------	---	---	--	--	--

D3608-3

Upper Doubler

DAS
27
9-89

Location 141120
Loc Qty 15
Loc Code

**

DAS
28
9-89

JUN 17 2016

Do not pull

SH
147167
616116

DART SERVICE INSTRUCTION

**TO AMEND INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A
AND INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0**
REF. TCCA STC SH08-53
REF. FAA STC SR02692NY
REF. EASA STC EASA.IM.R.S.01529

It has come to Dart's attention that due to variances in airframe, the D3608-1/-3 Lower/Upper Doublers of the D412-775-013 Step Protective Trim Kit at CHG 001 may not always fit as intended. To ensure proper fit, Dart has made changes to both D3608-1/-3 Doublers at CHG 002 and later. The manuals listed above are amended as follows:

IS:

INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A, SECTION 3.2

3.2.5 Locate the D3608-1/-3 Doublers per Figure 3 and 4 and transfer drill #28 ($\varnothing 0.141$ ") holes from the aircraft to the D3608-1/-3 Doublers. Bend tabs on D3608-1/-3 Doublers as shown in Figure 1 of this service instruction and trim rectangular opening as required to fit airframe.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0, SECTION 53.4

53.4.2 Locate the D3608-1/-3 Doublers per Figure 53-2 and 53-3. If the D3608-1/-3 doublers are being replaced, transfer drill #28 ($\varnothing 0.141$ ") holes from the aircraft to the D3608-1/-3 Doublers. Bend tabs on D3608-1/-3 Doublers as shown in Figure 1 of this service instruction and trim rectangular opening as required to fit airframe.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

WAS:

INSTALLATION INSTRUCTIONS IIN-D412-775 REV. A, SECTION 3.2

3.2.5 Locate the D3608-1/-3 Doublers per Figure 3 and 4 and transfer drill #28 ($\varnothing 0.141$ ") holes from the aircraft to the D3608-1/-3 Doublers.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

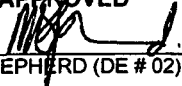
INSTRUCTIONS FOR CONTINUED AIRWORTHINESS ICA-D412-775 REV. 0, SECTION 53.4

53.4.2 Locate the D3608-1/-3 Doublers per Figure 53-2 and 53-3. If the D3608-1/-3 doublers are being replaced, transfer drill #28 ($\varnothing 0.141$ ") holes from the aircraft to the D3608-1/-3 Doublers.

NOTE: To avoid sharp edges or interference between the crew door, hinged panel door and step door assemblies, it is acceptable to trim the D3608-1/-3 Doublers to fit.

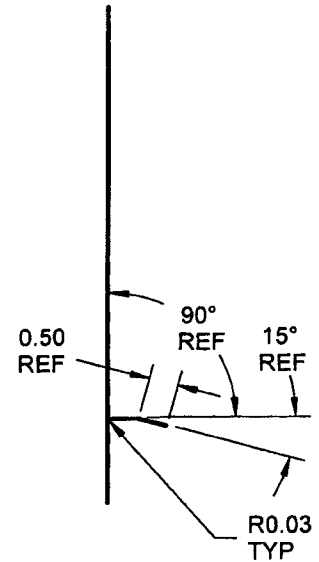
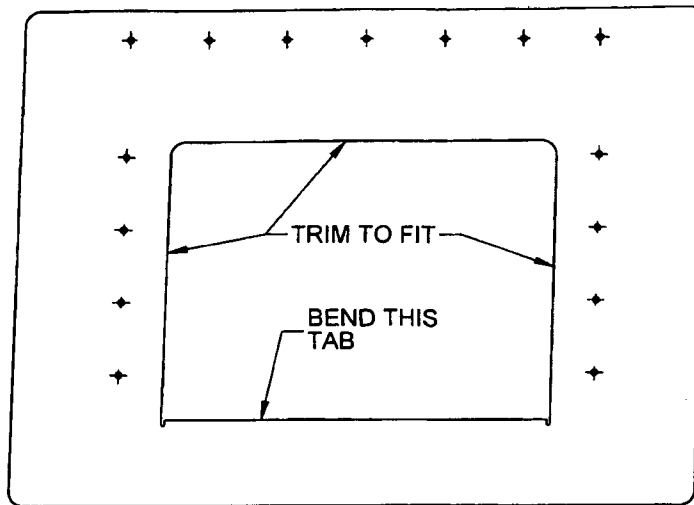
CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED

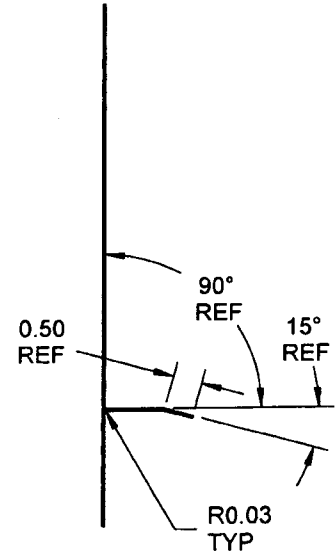
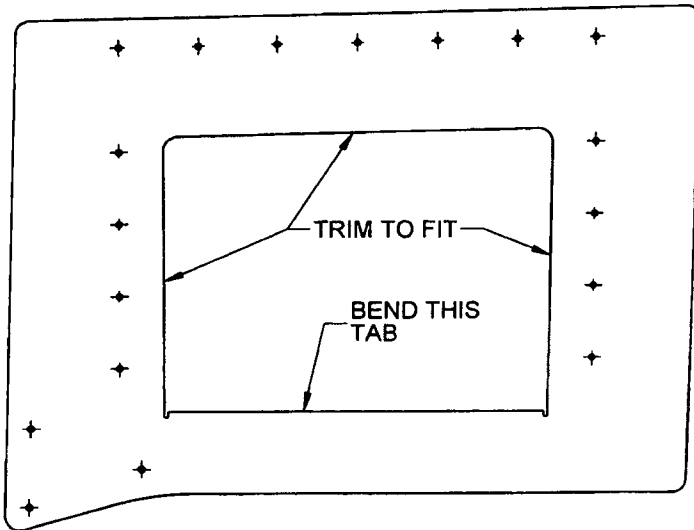
BY: 
D. SHEPHERD (DE # 02)

DATE: 10.02.05
CERT. NO.: SH08-53
ISSUE NO.: 1

A	NEW ISSUE	MB	10.02.05
REV.	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN			
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9503	SHEET 1 OF 2
APPROVED		TITLE	SCALE
DE APPR.		STEP PROTECTIVE TRIM CHG NTS	
DATE	10.02.05	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	



D3608-3 BENT UPPER DOUBLER



D3608-1 BENT LOWER DOUBLER

CANADA
DEPARTMENT OF TRANSPORT
AIRCRAFT CERTIFICATION
BRANCH
DAO # 01-O-01

APPROVED
BY: *[Signature]*
D. SHEPHERD (DE # 02)

DATE: 10.02.05
CERT. NO.: SH08-53
ISSUE NO.: 1

FIGURE 1: TRIMMING/BENDING OF D3608-1/-3 DOUBLERS
(PARTS SHOWN PRIOR TO TRANSFER DRILLING)

DESIGN	<i>[Signature]</i>	DART AEROSPACE LTD	
DRAWN	<i>[Signature]</i>	HAWKESBURY, ONTARIO, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9503	SHEET 2 OF 2
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	STEP PROTECTIVE TRIM CHG	
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5.0 PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-775-011	DOOR SILL PROTECTIVE TRIM KIT
	X		D412-775-013	STEP PROTECTIVE TRIM KIT
		X	D412-775-015	FUEL PANEL PROTECTIVE TRIM KIT
2			D3602-1	ANGLE
	1		D3608-1	LOWER DOUBLER
	1		D3608-3	UPPER DOUBLER
		1	D3609-1	DOUBLER